Work Orde July-31-14 9:24	er ID 123190 0:53 AM	0		*123	190*							Page 1
Item ID: Revision ID:	D3508-11			Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Stainless Steel Wear	plate Aft Center								Stop	*//	S2*
Start Date: Required Date: Reference:		rt Qty: 8.00 q'd Qty: 8.00	*8* *8*	5.	Cust Item I						"IV,	コン ^
Approvals:	Process Plan:	\mathcal{N}	Date:	Tooling:	D	ate:	 		Run	Start	*N	R1*
	QC:		_ Date:	SPC (Y/N):	D	ate:				Stop	*NI	R2*
Sequence ID/ Work Center ID		ration ription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp.
Draw Nbr	Revision 1	Nbr					Couc	- Qij	Qty			Stamp
D3508	Rev C									,		
100 *1		V WATER JET Memo		0.00				8			mm	14/08/01
FLOW CNC Waterje	, , , , , , , , , , , , , , , , , , ,	1-Cut as per Deburr if ne	Dwg D3508 Dwg Rev: cessary	C Prog Rev: C	_ 2-							
110	QC2-	Inspect parts off m	achine FAI/FAIB	0.00								
110 QC Quality Control		Memo		0.00	~ ·· <u>-</u>	-		<u>(§)</u>			MM	17/08/01
			•				44.	•• .			•	
120 *1 00 *	QC8-1	Inspect parts - seco	nd check	DAS 0.00 38 9-89			مارش ق مراس	A			· •	
120 QC Quality Control		Memo		0.00 /4/08/0/	,			3	9)			

DQA:		. Date:												
	٠				WORK ORDER NON-	-CC	ONFO	RMANCE / UPD					_	AEROSPACE
QA Closed:		Date:				_				Wor	k Order up	date only		<u> </u>
Work Orde	r:				DISPOSITION				AGAINST [DEP/	ARTMENT	/PROCESS		·
	··-				Rework			Skid-tube (Crosstube	\neg		Water Jet		Engineering
Part N	0.				Scrap			—	Small Fab	┪	Pro	d. Eng. Coor.	-	Quality
					Use-as-is			noforming	Finishing	┪		e/Packaging	-	Other
NCR N	0.				Suspected Unapproved			Large Fab C	omposite	7	•	Supplier	-	
									_				_	<u> </u>
Root				Desci	ription of work order update	1	Initial	Action	1		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descripti	ion		Date	Verificatio	n	QC Inspector
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						FAI	ULT CAT	regory						· · · · · · · · · · · · · · · · · · ·
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-	Bending			_	Bend		- i	rogram	-	_	outside Dime		H	Pressure/Forced
-	Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain		-	—	ver/Under		-	Set-up
-	Cracks	ala (Dimada	/\4/	<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		القامط ا		art Incorred		⊢	Temperature/Cure Weld
-	Crimp/Kir	ік/кірріе	:/wave	-	Burrs	H	i .	ion Incomplete/Unqui	F	_	art Lost/Mi	ssing	<u> </u>	Wrong Stock Pulled
ŀ	Crushing			<u> </u>	Contamination Countersink		4	ions Incomplete/Uncl gned/off center	leai	_	art Moved ositioned W	Vrong	L	AALOUR STOCK LUILED
-	Crushing Heat Trea	.+		-	Cut Too Short	\vdash	Mislabe		-	_	ower Loss/	-	Г	Other
}	Inspection		Tuba	-	Drawing	-	Misread		L		OWEI LUSS/.	Juige	<u> </u>	Odici
}	Marks/Ch		Tube		Drill Holes		Off-set	4		-				
}	Turning S				Finish	-	4	Calibration		_				
}	Wave/Tw				Fit/Function		4	Sequence		_				
			-	1	.,	1	1	<u> </u>						

Work Ord <i>July-31-14 9:2</i>		23190		*123	R190*		The state of the s				Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	7/31/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N9000 Cust Item ID: Customer:	401	೧ ೧*	Setup	Start Stop	171	S1* S2*
Approvals:	Process Pl	an:	Date:	Tooling:	Date:			Run	Start Stop	~1/1	R1*
Sequence ID/ Work Center II 130 *1.20* Brake NC Brake NC		Operation Description NC BRAKE Memo 1-Form on br		SPC (Y/N): Set Up/ Run Hours 0.00 0.00 OT8261as per Dwg D3508	Tool ID T	Tool# Pl	an Acce ode Qty	pt Re Qt	ject	*N Reject Number	R2* Insp. Stamp
140 *1 40* QC Quality Control		QC5- Inspect part comple Memo	teness to step on W/O	0.00 DAS 0.00 16 1/10	&k7		69	<u> </u>			<u> </u>
*150 *150* Powdercoat Powder Coating		Grey Sandtex(Ref:4.3.5.6) Memo START TIME 320 F	125028	0.00 0.00 OVEN TEMPERATURE:			9				DAS 41 9-89

DQA:		- -	Date:			WORK ORDER NON	c	NEO	DAAANCE / HI	DATE			~DART
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Work Orde	r.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	o		'			Rework Scrap Use-as-is Suspected Unapproved	:		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desc	ription of work order update	Ī	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
11!							FAI	JLT CAT	EGORY				
Landin		ending Centre No Cracks Crimp/Kir Cuffs Crushing Jeat Trea Aspection Marks/Ch	Strip in	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Un ions Incomplete/U ned/off center lled	<u> </u>	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
[\neg	Vave/Tw	ist in Tub	е		Fit/Function		Out of S	Sequence				

Work Orde July-31-14 9:24		123190			*123	3190*							Page 3
Item ID: Revision ID: Item Name:	D3508-	Steel Wearplate Aft Center			Accept	*N900	<u>040</u>	100)*	Setup	Start	*N	S1*
Start Date: Required Date: Reference:	7/31/14	Start Qty: 8.00 Req'd Qty: 8.00		*8* *8*		Cust Item I	ID:				Stop	*N	S2*
Approvals:	Proces	s Plan:	Date:_		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1*
Sequence ID/ Work Center II 160 *160* QC Quality Control		Operation Description QC3- Inspect Part Finish Memo	<i></i>		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	ect I	*N Reject Number	R2* Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Stoo Memo	ck Locatio	n: <u>[</u> -[² 00	7 0.00 0.00				_			IL	14/08/1
180 *1 2 0 * QC Quality Control		QC21- Final Inspection - V	Work Order	r Release	0.00				Д	ΛLI	<u>5 1</u> !	4-08	-11

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QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		W	ork Order uj	odate only	\neg	AEROSPACE
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1 41 (1	•0.					Use-as-is		1	noforming	Finishing		4	re/Packaging	\dashv	Other
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	Н	Bending			_	Bend		4	rogram			Outside Dim	۲-	_	Pressure/Forced
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	—	Crimp/Kir	nk/Ripple,	/Wave		Burrs	L	1 '	ion Incomplete/Und	· •		Part Lost/Mi	issing	-	Weld
	\vdash	Cuffs				Contamination	<u> </u>	4	ions Incomplete/U	nclear		Part Moved	Ł		Wrong Stock Pulled
	-	Crushing				Countersink	_	1 1	ned/off center			Positioned V			
	\vdash	Heat Trea				Cut Too Short	L	Mislabe				Power Loss/	Surge	<u></u>	Other
	-	Inspection		Tube		Drawing		Misread							
		Marks/Ch	atter			Drill Holes		Off-set							
	${m extstyle extstyle $	Turning S				Finish		Out of (Calibration						
	ıl	Wave/Tw	ist in Tub	e	1	Fit/Function	1	Out of	Sequence						

Page 1

Work Order ID: 123190

123190

Parent Item:

D3508-11

D3508-11

Parent Item Name: Stainless Steel Wearplate Aft Center

Start Date: 7/31/14

Required Date: 8/08/14

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07.06.12

IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	295,2519	0.5887				
M304S20 304/316 .040 Sheet	GA							273.2319	**	·	mm	19/	98 / 01

Location	Loc Qty	Loc Code	
MAT020	295.2518948		
m126852	0.31		-
m127454	26.1018948		
m128435	117.14		
m129128	6.5		•
m129530	10.2		
m129845	135		(5)

DQA:		_ Date:												TRAG
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QA Closed.		Date.								VV	ork Order up	date only		
Work Orde	r:			:	DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework			Skid-tube	Crosstube]	Water Jet		Engineering
Part N	0.				Scrap			Machining	Small Fab	_	Pro	d. Eng. Coor.		Quality
					Use-as-is		Therr	noforming	Finishing		1	re/Packaging		Other
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Root				Descr	iption of work order update		nitial	Act	ion		Sign &			
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Ļ	Centre N	ot Conce	ntric		BOM/Route		Grain			_	Over/Under	- F	4	Set-up
}	Cracks				Broken/Damage/Defect		Hardwa			ļ	Part Incorre	- H		Temperature/Cure
].		nk/Ripple	e/Wave	<u> </u>	Burrs	-	1 '	ion Incomplete/Ur		<u> </u>	Part Lost/Mi	ssing		Weld
	Cuffs				Contamination	-	4	tions Incomplete/L	Jnclear	_	Part Moved	L		Wrong Stock Pulled
ļ	Crushing				Countersink		1	gned/off center			Positioned V	· ·		
ļ <u>.</u>	Heat Tre				Cut Too Short		Mislabe			L	Power Loss/	Surge [Other
<u> </u>	⊣ `	on Strip in	Tube		Drawing		Misread	*						
	Marks/C				Drill Holes	<u> </u>	Off-set							
ļ.		Sequence			Finish	<u> </u>	-	Calibration						
ŀ	Wave/T	vist in Tu <mark>l</mark>	эe		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	123190
Description: Wearplate	Part Number:	D3508-11
Inspection Dwg: D3508 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

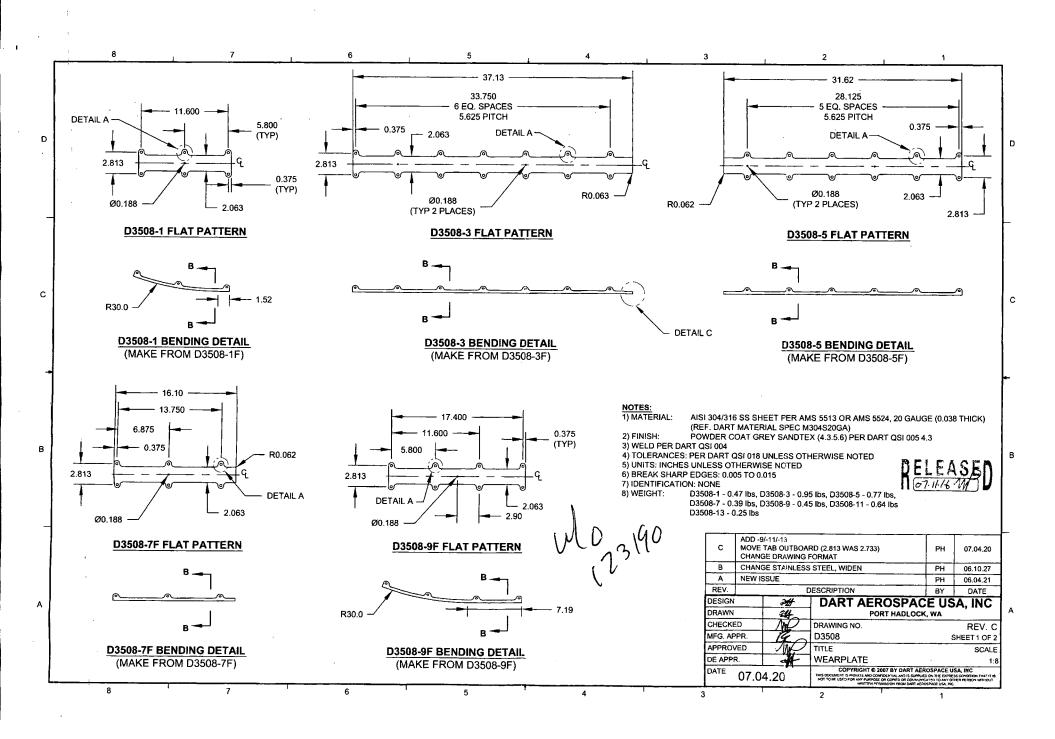
X First Article Prototype

Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+/-0.010	7.063			T-3km.06	
+/-0.010	J.	V		i I	
+/-0.010	í			0 0 0 2 201	
+/-0.010		l			
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	+/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +0.005/-0.001 +/-0.010	Dimension	Dimension Accept	Dimension Accept Reject	Dimension Accept Reject Inspection

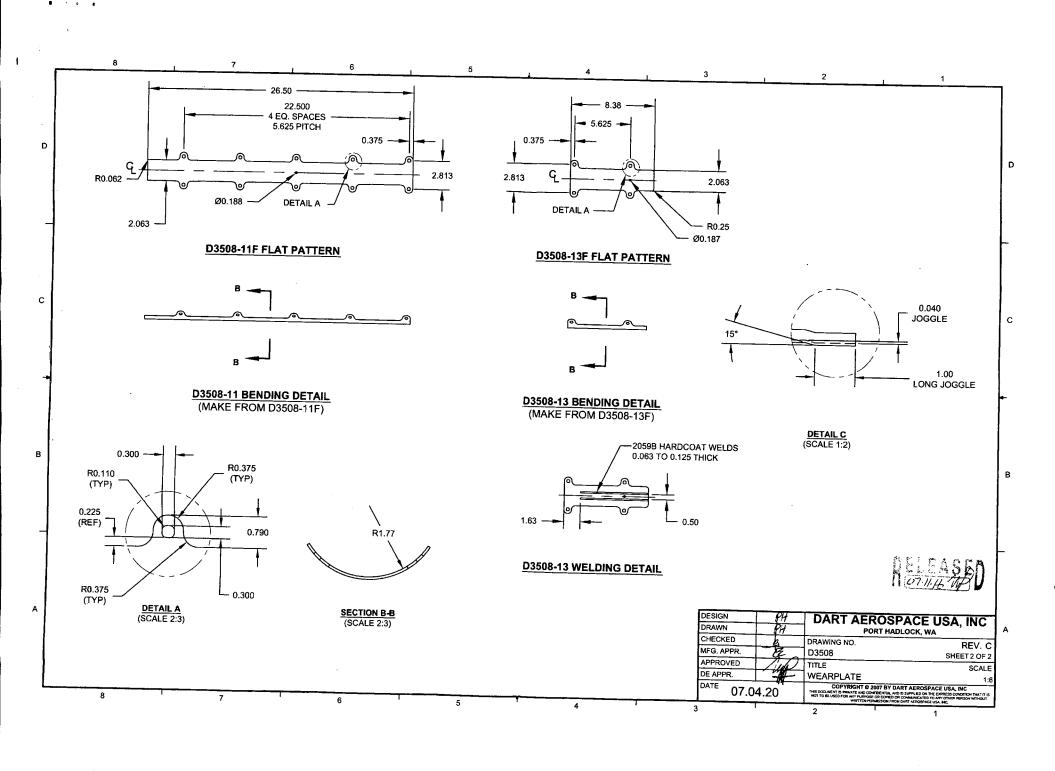
Measured by:	mm	Audited by:	DAS 16	Prototype Approval:	N/A
Date:	14/08/01	Date:	9-89 /4/48//2	Date:	N/A

Rev	Date	Change	Revised by a	Annuovad
Α	08.07.24	New Issue	KJ/DD KJ	Approved
			110000 278	

DQA:			Date:						_					TRAGE
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Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part N	lo.					Scrap		ı	Machining	Small Fab	Pro	Quality		
	_					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier		
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		Cuffs			\vdash	Contamination		1	tions Incomplete/Unc	clear	1	L		Wrong Stock Pulled
		Crushing			. -	Countersink		-	gned/off center	<u> </u>	4		\neg	
				Cut Too Short	_	Mislabe		L	Power Loss/S	Surge		Other		
	_	Inspection		Tube	<u> </u>	Drawing	-	Misread						-
	-	Marks/Ch			-	Drill Holes	-	Off-set						
-	$\overline{}$	Turning S	-		-	Finish	-	1	Calibration					
Wave/Twist in Tube					L_	Fit/Function		JOut of S	Sequence					



DQA:			_ Date:			_									
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QA Closed: Date:											W	ork Order up	odate only		<u> </u>
Work Order:			DISPOSITION	DISPOSITION AGAI					PARTMENT						
						Rework		Skid-tube Cros			Water Jet				Engineering
Part N	No.					Scrap		Machining Small			_	Prod. Eng. Coor.			Quality
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	Cracks			Broken/Damage/Defect	_	Hardware			_	Part Incorre	ŀ		Temperature/Cure		
Crimp/Kink/Ripple/Wave			-	Burrs	-	Inspection Incomplete/Unqualified			⊣	Part Lost/Mi	issing		Weld		
	Cuffs		<u> </u>	Contamination		4	ions Incomplete/U	Inclear	\vdash	Part Moved	· [Wrong Stock Pulled		
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	\vdash	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set							
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QA Closed.			Date.			<u> </u>				VV	ork Order u	odate only		
Work Order:			DISPOSITION			AGAINST	AGAINST DEPARTMENT/PROCESS							
	•					Rework	1		Skid-tube Crosstube	•	Water Jet			Engineering
Part N	No.					Scrap	1		Machining Small Fab		—			Quality
•					,	Use-as-is	1	Thermoforming Finishing Rec/Store/Package						Other
NCR N	lo.		** **			Suspected Unapproved]		Large Fab Composite	-	Supplier			
Root					Desc	ription of work order update		Initial	Action		Sign &		1	
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		Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
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С		Cracks				Broken/Damage/Defect		Hardware			Part Incorrect			Temperature/Cure
Crimp/Kink/Ripple/Wa		/Wave		Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/Missing			Weld		
Cuffs				Contamination		Instructions Incomplete/Unclear			Part Moved			Wrong Stock Pulled		
Crushing		Countersink	_	4	gned/off center	\perp	Positioned V	- r		,				
—		Heat Trea				Cut Too Short	7	Mislabe		L	Power Loss/	Surge		Other
Inspection Strip in Tube				Drawing	_	Misrea						·		
		Marks/Ch				Drill Holes	_	Off-set						
		Turning S	-			Finish	_	4	Calibration					
	Wave/Twist in Tube					Fit/Function		Out of	Sequence					